

Date: Wednesday, 11/21/2007 12:47:42 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
 Job Number : 35918
 Estimate Number : 10534
 P.O. Number : N/A Part Number : D2574
 This Issue : 11/21/2007 S.O. No. : N/A Drawing Number : D2574 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 34840 Material : N/A
 Due Date : 1/15/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: I As Per RevE 06-01-27 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: B 31388

mk 07/12/14

(12)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 35918 Double check by: *TC*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

sf 07/12/15

mk

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

mk / sf 07/12/15

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk / sf 07/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.12.20	2	Qty (1) part gouged during tumbling	CP 07.12.20 pv QSI 642	SCRAP history was kept ref 704	JS 07/12/20	π	MS 07/12/20	07/12/20

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 35918

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JA 08.01.03

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-01-04

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

~~W~~ Powder Coat **SANDTEX GREEN** ~~W~~
(Ref: 4.3.5.1) as per QSI 005 4.3

M 102 316

BR 08-01-08

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

CV 8/6/9

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

W AS

08/01/09

(X12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Doelatt

Job Completion



W 08.01.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35918
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.439	.440	.441	.441		
B	1.745	1.755		1.750	1.750	1.749	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.749	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	0.500	0.502		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.375	.375	.375		
I	0.490	0.510		.509	.508	.508	.506		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.569	.568	.568	.568		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.124	4.124	4.124		
P	0.115	0.135		.125	.126	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.250	.251		
S	0.115	0.135		.117	.130	.126	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.233	3.231	3.231		
V	0.230	0.250		.232	.245	.242	.241		
W	0.115	0.135		.125	.125	0.125	0.127		
X	0.307	0.312		0.309	0.310	0.309	0.310		
Y	0.760	0.765		0.760	0.761	0.761	0.760		
Z	0.352	0.372		0.372	0.372	0.372	0.372		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.628	0.627	0.628		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.512	1.510	1.510	1.511		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.265	.265	.270		
AH	0.240	0.260		.242	.242	.250	.247		
AI	2.000	2.020		2.003	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	RF / 19m
Date:	07/12/15 07/12/19

Audited by:	SN
Date:	08/01/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 35918
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	58	68	87	A8	By	Date
A	0.438	0.443		0.441	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.499	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.998	7.998	7.998		
F	0.490	0.510		0.502	0.502	0.502	0.501		
G	0.257	0.262		.258	.258	0.259	0.259		
H	0.375	0.380		.375	.375	0.376	0.377		
I	0.490	0.510		0.506	0.504	0.502	0.502		
J	1.174	1.184		1.180	1.180	1.178	1.178		
K	0.558	0.578		0.572	0.569	0.569	0.570		
L	1.174	1.184		1.180	1.180	1.178	1.178		
M	1.365	1.375		1.370	1.370	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.499	2.501		
O	4.119	4.129		4.124	4.124	4.121	4.124		
P	0.115	0.135		.125	.125	0.125	0.118		
Q	0.115	0.135		0.145	0.130	0.135	0.135		
R	0.240	0.260		.250	.250	0.249	0.240		
S	0.115	0.135		0.126	0.122	0.124	0.123		
T	0.178	0.198		.188	.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.237	0.236	0.237	0.237		
W	0.115	0.135		0.130	0.130	0.135	0.135		
X	0.307	0.312		0.310	0.310	0.311	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.367	0.367	0.370	0.372		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.627	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	.250	0.247	0.247		
AE	1.500	1.520		1.510	1.510	1.510	1.505		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		.265	.265	0.265	0.269		
AH	0.240	0.260		0.249	0.248	0.247	0.249		
AI	2.000	2.020		2.002	2.002	2.002	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: RF	10ml
Date: 02/12/17	07/12/19

Audited by: SA
Date: 08/01/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	35918
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

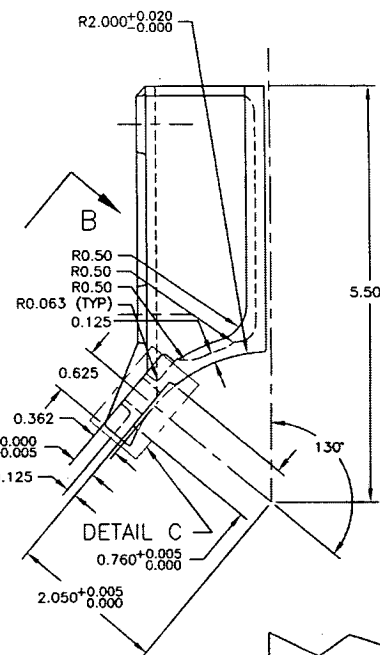
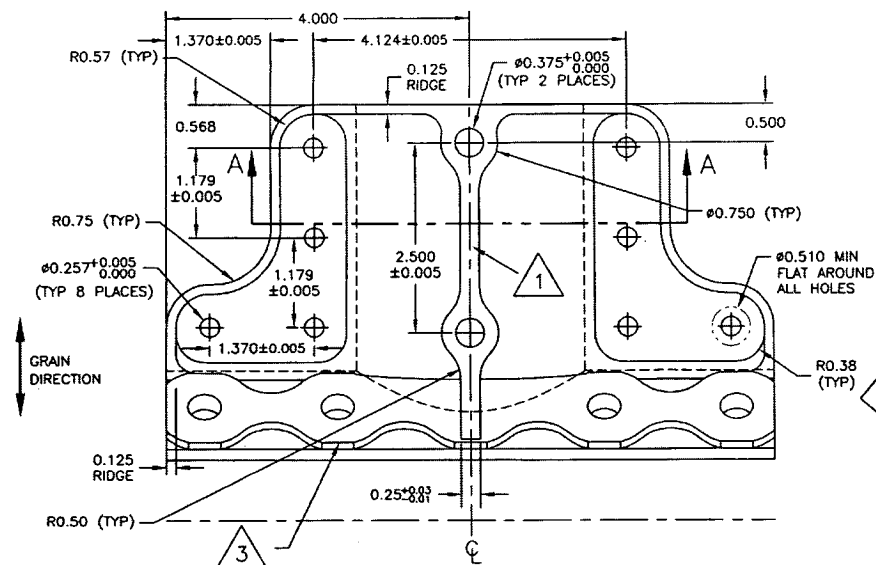
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	311	412	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		0.501	0.501	0.500	0.502		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.375		
I	0.490	0.510		0.501	0.502	0.503	0.503		
J	1.174	1.184		1.172	1.178	1.178	1.180		
K	0.558	0.578		0.569	0.570	0.570	0.570		
L	1.174	1.184		1.172	1.178	1.178	1.180		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.122	4.121	4.121	4.124		
P	0.115	0.135		0.126	0.126	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.248	0.249	0.250		
S	0.115	0.135		0.120	0.122	0.123	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.233		
V	0.230	0.250		0.236	0.238	0.237	0.237		
W	0.115	0.135		0.133	0.133	0.133	0.135		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.366	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.251	0.251	0.251		
AE	1.500	1.520		1.511	1.511	1.511	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.270	0.260	0.265	0.265		
AH	0.240	0.260		0.247	0.248	0.249	0.250		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	CMK / SF
Date:	07/12/19 / 07/12/20

Audited by:	SD
Date:	08/01/20





Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

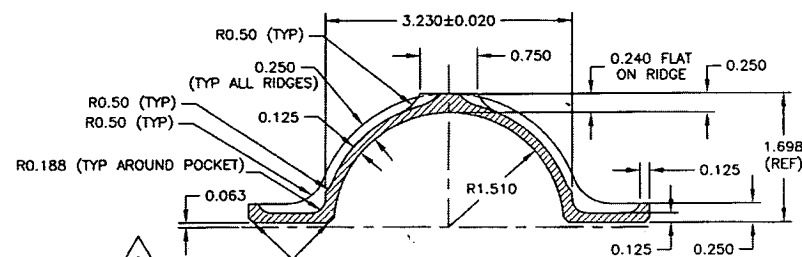
05.12.06 ~~ff~~



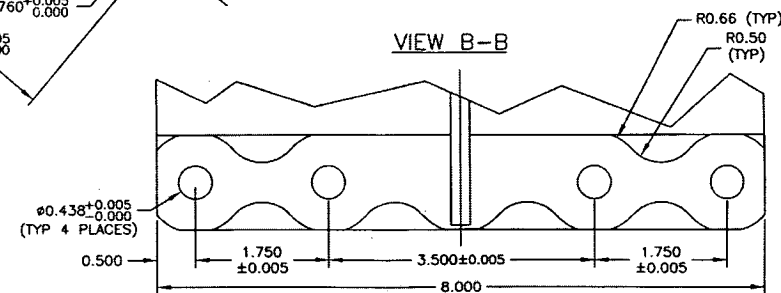
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

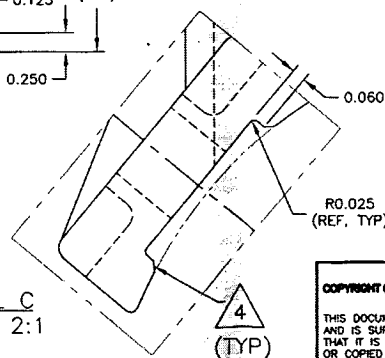
- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C) |






SECTION A-A



VIEW B-B



DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED 		APPROVED 
DATE 05.07.13		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
		DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		REV. SHEET 1 OF 2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35918